

Date: Monday, 11/19/2007 4:06:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350 STEP END PLATE		
Job Number	: 35887		Part Number	: D267334		
Estimate Number	: 11015		Drawing Number	: D2673 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/19/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/15/2007 Qty: 200 Um: Each		
Previous Run	: 32404					
Written By						
Checked & Approved By						
Comment	: Est. C 02-01-14 Removed deburr and inspect level 5 NG/EC Est Rev:D Now 6061-T6 06-06-23 JLM Est Rev:C Now on Waterjet 07-05-28 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		 Comment: Qty.: 0.1913 sf(s)/Unit Total : 38.2620 sf(s) 4B07-11-21 6061-T6 .080 Sheet M103755 x 40 = 17.217 (M6061T6S080) M103961 x 70 = 13.391 Note: 1 Blank makes 2 M103961 x 40 = 7.652 Material Batch M104186
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 4B 07-11-21 1-Cut as per Dwg D2673 Dwg Rev: B Prog Rev: B
		 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 4B 07-11-21
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 QSP019 8/11/23
		 Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W2

11/19/2007

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/19/2007

Job Completion



11/19/2007

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35887
Description: End Plate	Part Number:	D2673-34
Inspection Dwg: D2673	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article □ Prototype

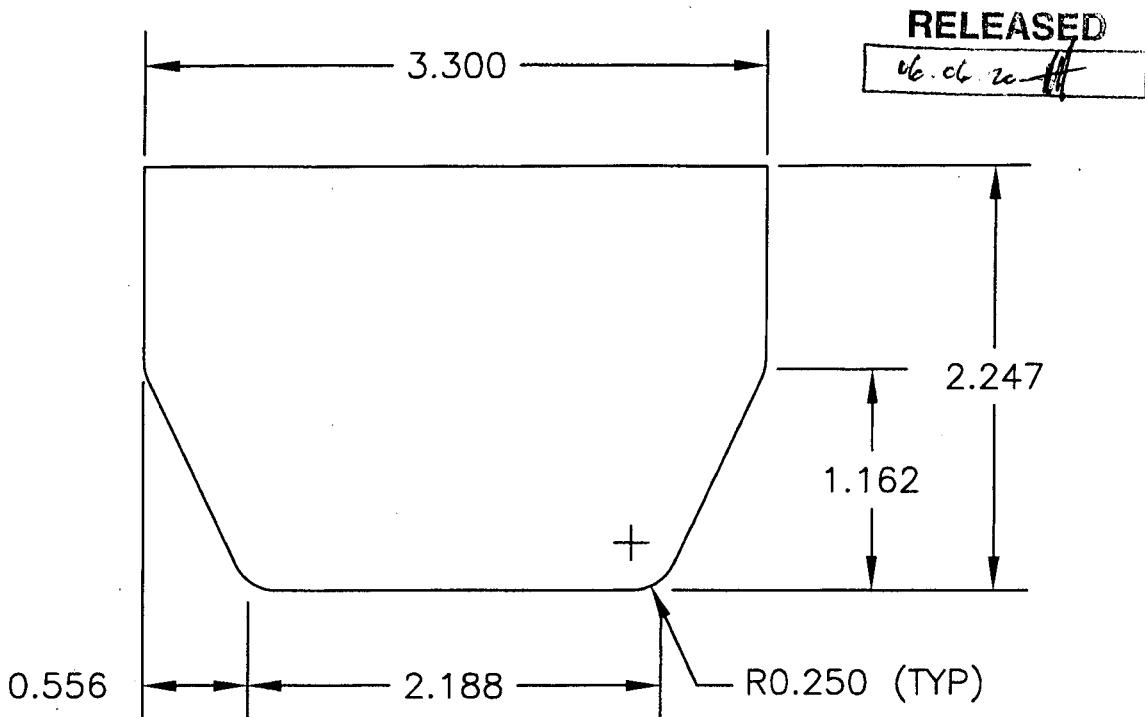
Measured by: HB	Audited by: C	Prototype Approval: N/A
Date: 07-11-21	Date: 07-11-23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
B	04.06.15	Remove 1.162, 2.188 & 0.556 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	AA

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2673	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE END PLATE	SCALE 1:1
A	97.05.06	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

END PLATE FOR D2244 EXTRUSION CUT AT 34°

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080) UNCONTROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE
WORK ORDER
NO. 3588-7

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